

Date: Tuesday, 28/08/2007 10:42:44 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOUSING WELDMENT
Job Number : 33982	
Estimate Number : 11874	
P.O. Number :	Part Number : D2207041
This Issue : 28/08/2007 S.O. No. :	Drawing Number : D2207 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 16/08/2007 Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 32219	Material :
Written By :	Due Date : 23/08/2007
Checked & Approved By :	Qty : ③ Um: Each
Comment : Est. 01.10.18 Added Step 10 and 11 SM	

OK PER
D2207 REV. C PERUM
ISSUE
16/08/2007

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 D2208 End Cap



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

End Cap

Pick:

Qty	Part Number	Description	Batch
2	D2208	End cap	B33239

PD 07-09-27 (3)

2.0 D22071 Housing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Housing

Pick:

Qty	Part Number	Description	Batch
1	D2207-1	Housing	B34326

PD 07-09-27 (3)

3.0 LARGE FAB.1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2207

Grind welds flush as per Dwg D2207

PD 07-09-27 (3)
G.M. 07-09-28 (3)

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QCS 11/09/28
QC9 11/09/28 (3)

(C)

(C)

(C)

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(C)

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Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

FF 07-09-28 3

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 01/09/28 x3

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ml 01/09/29

(3)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 105068.

FD 07/10/01 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 07/10/02 (3x)

10.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Insert

Qty Part Number

Description Batch

4 ALS7-1032-130

Insert

M 125791

SEE QSI 017

07/10/02

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

ml 07/10/02 (3x)

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/10/02 (3)

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Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/10/02

(3)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.10.02
[Signature]

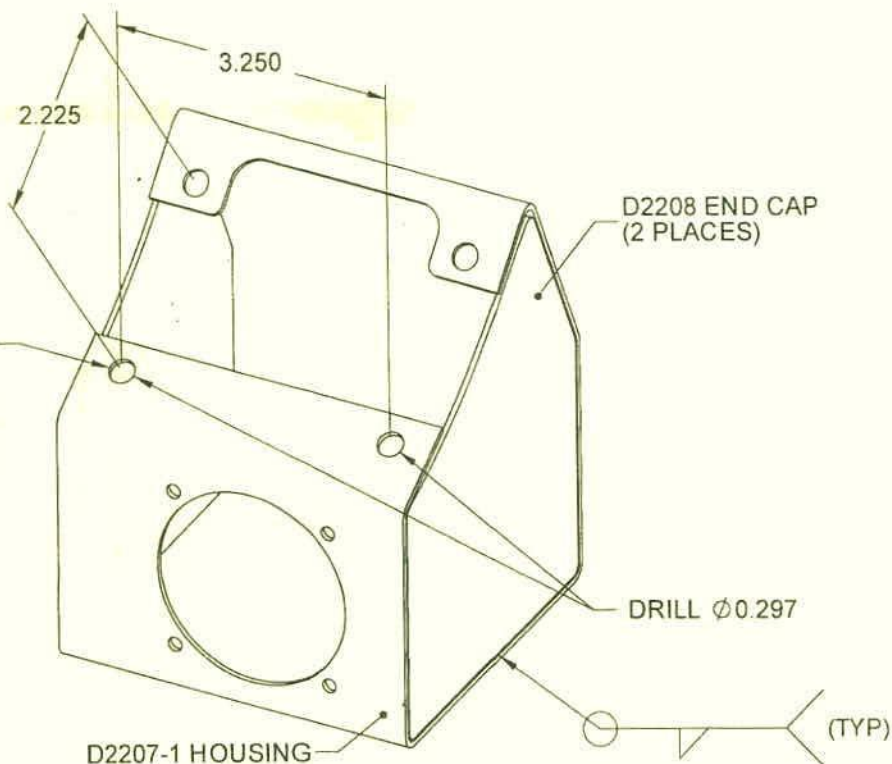
Job Completion



07.10.02

2.948
297
345

AFTER FINISH, INSTALL
AKS7-1032-130 OR
ALS7-1032-130 OR
AKS4-1032-130 OR
ALS4-1032-130
(4 PLACES)



D2207-041 HOUSING ASSEMBLY

PRELIMINARY/ISSUE

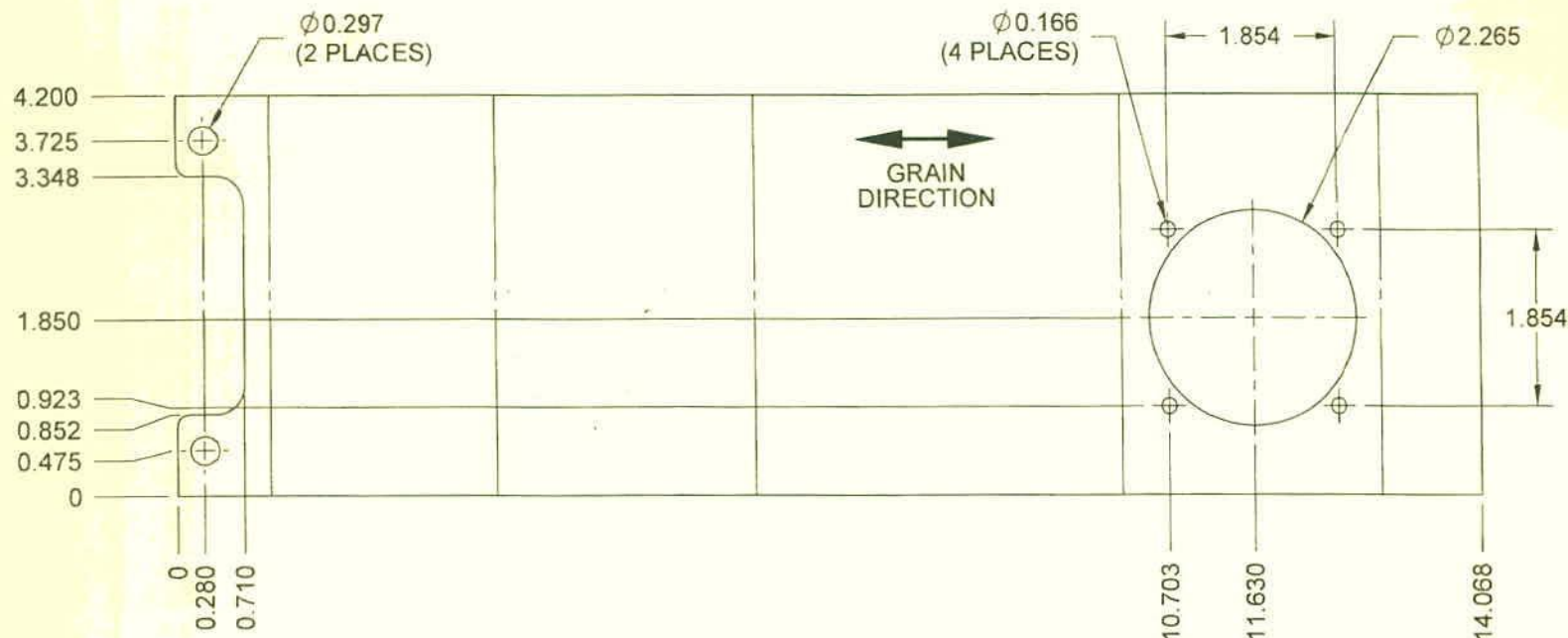
07.06.28

1.925
297
372

NOTES:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: ACID ETCH AND ALODINE PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

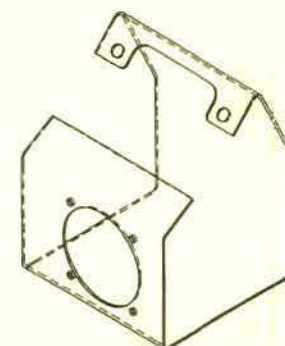
REV.	DESCRIPTION	BY	DATE
C	- UPDATE FLAT PATTERN - TOOLING REWORK REQUIRED	MB	07.06.28
B	REDRAWN	RF	01.02.23
A	NEW ISSUE	RF	94.09.01
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2207 REV. C SHEET 1 OF 2 TITLE HOUSING SCALE 1:2 <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSONAL WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>		
MFG. APPR.	<i>EE</i>		
APPROVED			
DE APPR.		DATE 07.06.28	



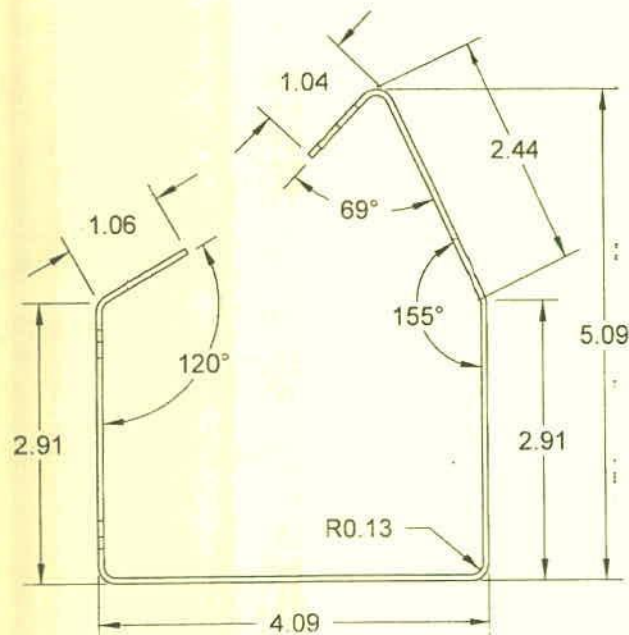
D2207-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.063) OR
6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



ISOMETRIC VIEW
(SCALE 1 : 4)



D2207-1 BENDING DETAIL

PRELIMINARY ISSUE

DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>PH</i>	D2207	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HOUSING	1:2
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